

Work Order ID 58608 - 2

May 12, 2010 10:30:19 AM

Page 1

Item ID: D412-630-032

Accept

Revision ID:

Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 12/05/2010 Start Qty: 2.00

Required Date: 18/05/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 10-5-12 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

S 10/06/06

Star for BG 10/06/03

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****
A/R MS20995C41 batch: 1101537

JS 10/05/31 (5)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

****ensure tension to retract step is 11 to 18 lbs ****
Test fit on aircraft in Eng. lab.

S 10/05/31

(+5)
RH

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Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 12/05/2010 Start Qty: 2.00



Required Date: 18/05/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Pick Kit

0.00

3/ (52)

10-6-35

ATO →

Memo

0.00

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

5066108

Memo

0.00

(23 RH)

150



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

Ref 3

Work Order ID 58608

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Page 3

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 12/05/2010 Start Qty: 2.00



Required Date: 18/05/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08

M10-6-08
③

Picklist Print

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Page 1

Work Order ID: 58608

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD

Start Date: 5/12/10

Required Date: 5/18/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN310-4		Purchased	No			#130	Each	81.0000	21	4			

Location	Loc Qty	Loc Code
ST139	21	
114341	21	
ST324	47	
114716	47	
ST349	13	
114341	13	

AN310-4

Purchased

No

NUT

Location	Loc Qty	Loc Code
ST139	21	
114341	21	
ST324	47	
114716	47	
ST349	13	
114341	13	

AN310-5

Purchased

No

NUT

Location	Loc Qty	Loc Code
ST314	39	
113845	39	

Sh 10/05/26 (5)

10-6-4 SP

11/14/30

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Work Order ID: 58608

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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Date: 5/12/10

Required Date: 5/18/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN310-7		Purchased	No				Each	9.0000	1	2			
													
NUT													

AN3C5A



Bolt

Purchased No

Location	Loc Qty	Loc Code
ST324	9	
111916	9	
	Each	453.0000

130

③
2
3 6
10-6-4 sl

Location	Loc Qty	Loc Code
ST350	325	
114330	125	
114523	200	
ST351	128	
113121	10	
114108	45	
114181	73	
	Each	32.0000

130

3
1 2
10-6-21 sl (50)

AN44-C12



eyebolt

Purchased No

Location	Loc Qty	Loc Code
ST356	12	
111888	12	
ST362	20	
114669	20	

5

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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Date: 5/12/10

Required Date: 5/18/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN4C14		Purchased	No				Each	33.0000	1	2			
													
BOLT													

Location	Loc Qty	Loc Code
ST358	33	
113899	13	
114669	20	
	Each	46.0000
		1 2
		10-6-3
		SB 10/5/26
		5
		5

Location	Loc Qty	Loc Code
ST358	46	
113618	6	
113908	20	
114669	20	
	Each	19.0000
		2 4
		10-6-3
		SB 10/5/26
		9
		114801
		5

Location	Loc Qty	Loc Code
ST355	19	
114669	19	
	Each	32.0000
		1 2
		10-6-3
		SB 10/5/26
		9
		114801
		5

Location	Loc Qty	Loc Code
ST337	32	
111279	8	
113422	12	
113950	12	
		5

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Work Order ID: 58608

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Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD

Start Date: 5/12/10

Required Date: 5/18/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN5C15		Purchased	No			#130	Each	38.0000	1	2		10-6-3	sl

Location	Loc Qty	Loc Code
ST338	30	
114669	30	
ST339	8	
110552	8	

AN960C10	NAS1149C0363 R	Purchased	No		#130	Each	0.0000	7	14				
----------	----------------	-----------	----	--	------	------	--------	---	----	--	--	--	--

AN960C516		Purchased	No		#130	Each	180.0000	1	2			10-6-3	sl
-----------	--	-----------	----	--	------	------	----------	---	---	--	--	--------	----

Location	Loc Qty	Loc Code
ST347	180	
102842	80	
112532	100	

D3443-041		Manufactured	No			Each	20.0000	1	2				
-----------	--	--------------	----	--	--	------	---------	---	---	--	--	--	--

Location	Loc Qty	Loc Code
GA	20	
58553	20	

D3443-043		Manufactured	No			Each	0.0000	1	2				
-----------	--	--------------	----	--	--	------	--------	---	---	--	--	--	--

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Work Order ID: 58608



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/12/10

Required Date: 5/18/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3443-9		Manufactured	No				Each	28.0000	2	4			



Pin

Location	Loc Qty	Loc Code
ST056	28	
58552	28	

D3454-1	Manufactured	No
---------	--------------	----



Bushing

Location	Loc Qty	Loc Code
ST058	43	
53745	3	
58555	40	

D3454-3	Manufactured	No
---------	--------------	----



Bushing

Location	Loc Qty	Loc Code
ST058	60	
56420	60	

D3454-5	Manufactured	No
---------	--------------	----



Bushing

Location	Loc Qty	Loc Code
ST058	42	
56046	22	
58556	20	

10 SB 10/05/24 (S)
10-6-3 SP

10-6-3 SP

10-6-3 SP SW

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Work Order ID: 58608



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/12/10

Required Date: 5/18/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 200

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3454-7		Manufactured	No				Each	20.0000	2	4			



Bushing

Location	Loc Qty	Loc Code
ST058	20	
55608	1	
58557	19	

55608
58557

20
1
19

9
8

EP 5/0/05/31
B59256 (M)

SB 10/05/20

D3455-1



Spacer

Manufactured No

Location	Loc Qty	Loc Code
ST058	79	B58558
56525	19	
58558	60	

56525
58558

79
19
60

4
5

SB 10/05/20

D3455-1



Spacer

Manufactured No

Location	Loc Qty	Loc Code
ST058	79	
56525	19	
58558	60	

56525
58558

79
19
60

4
11

B59469 94 P. 10/4/8

D3455-3



Spacer

Manufactured No

Location	Loc Qty	Loc Code
ST058	37	
56047	7	
58559	30	

56047
58559

37
7
30

10

10-6-3 (5x)

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Work Order ID: 58608



*Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/12/10

Required Date: 5/18/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-------------	-----------	------	--------



Bracket Assembly

Location

ST198A

Loc Qty

1

Loc Code

1

Each

0.0000

1

2

D3463-042



Step Weldment Assembly

D3465-1



Washer

Manufactured No

Manufactured No

Location

ST059

Loc Qty

37

37

Each

Loc Code

3,463.000

3

6

MS21043-3



Nut

Purchased No

Location

FG

103691

Loc Qty

80

80

3383

3383

ST301

112314

Loc Code

15

Handwritten notes and signatures:

- 258704
- 10-6-3
- B59471 30 (4/4/7)
- SB 10/05/26
- SB 10/05/26
- 10-6-3
- SB

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Picklist Print

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Work Order ID: 58608



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/12/10

Required Date: 5/18/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS24665-227		Purchased	No				Each	70.0000	1	4			



COTTER PIN

Location	Loc Qty	Loc Code
ST309	70	
113845	70	

MS24665-227



COTTER PIN

Purchased No

Each 70.0000

1 2



5 10-6-3 5/10/05/26 (5)

Location	Loc Qty	Loc Code
ST309	70	
113845	70	

MS24665-229



COTTER PIN

Purchased No

Each 189.0000

2 4



10-6-3 5/10/05/26 (5)

Location	Loc Qty	Loc Code
ST309	189	
111041	189	

MS24665-302



Cotter Pin

Purchased No

Each 72.0000

1 2



10 5/10/05/26 (5)

Location	Loc Qty	Loc Code
ST309	72	
113644	72	

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Shop Packet Print

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Picklist Print

May 27, 2010 1:20:35 PM

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Work Order ID: 58608



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/12/10

Required Date: 5/18/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
NAS1515H5		Purchased	No			A30	Each	255.0000	1	2			



Washer



10-6-3

SP 5x

Location

Loc Qty

Loc Code

FG	44	
103286	17	
103691	27	
ST277	211	
109430	211	

5

no stress

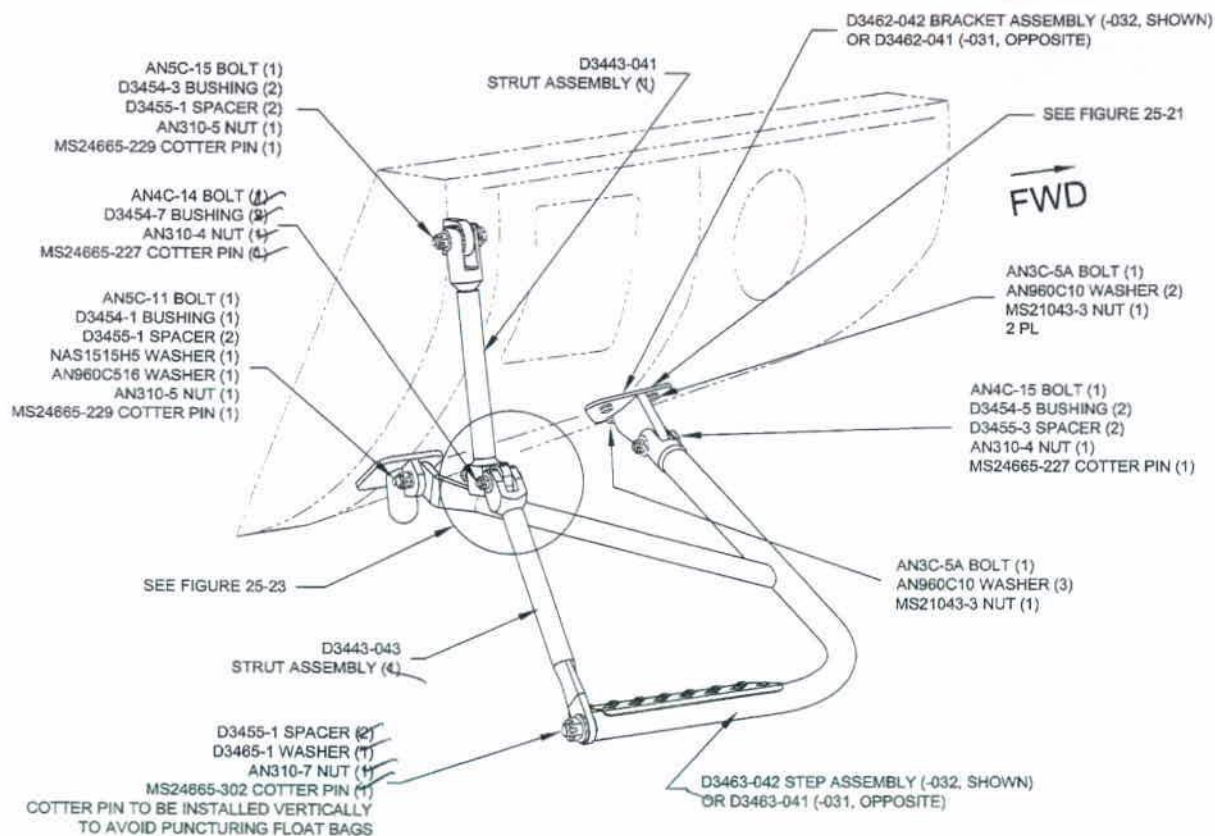


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

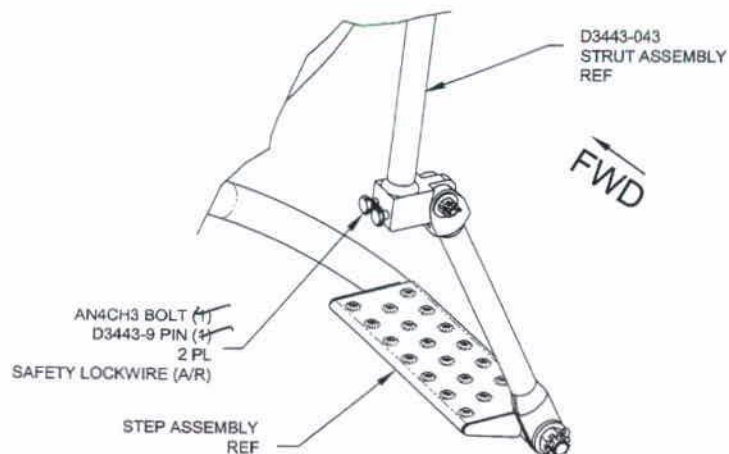
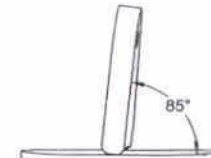
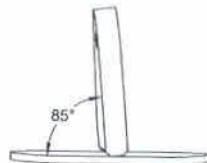
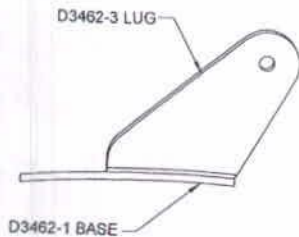
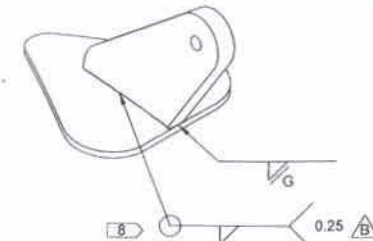
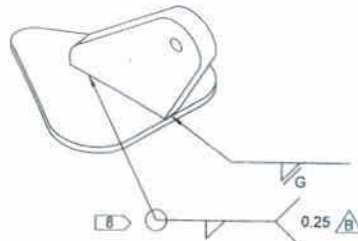
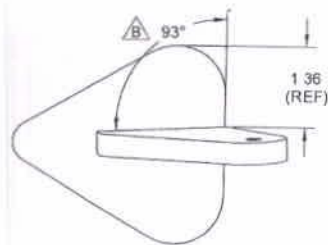


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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25-00-00

REFERENCE ONLY



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3462	SHEET 1 OF 2
MFG. APPR		TITLE	SCALE
APPROVED		BRACKET ASSEMBLY	1:2
DE APPR		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPARISONS TO ANY OTHER PRODUCT WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	07.10.24		

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT (-1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (-1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP